

# Work Order ID 59060

Tuesday, May 25, 2010 2:36:34 PM



Page 1

Item ID: D3876-7	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Protector - Aft Wall				
Start Date: 5/25/2010	Start Qty: 1.00		Cust Item ID:	
Required Date: 5/31/2010	Req'd Qty: 1.00		Customer:	
Reference:				

Approvals:	Process Plan: <u>H</u>	Date: <u>10-5-25</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	<b>Memo</b> 1-Cut as per Dwg D3876 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2- Deburr if necessary	0.00							
			SB 10/06/09						
						②			②
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	<b>Memo</b>	0.00							
120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	<b>Memo</b>	0.00							
			SB 10/06/09						
						②			

HB10-6-7

HB10-6-7

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 59060**

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Page 2

Item ID: D3876-7

Accept



Setup Start



Revision ID:

Item Name: Protector - Aft Wall

Stop



Start Date: 5/25/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

RP 59060 10-6-08

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/09 JJ

N 10-6-08  
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 25, 2010 2:36:38 PM

Page 1

Work Order ID: 59060



Parent Item: D3876-7



Parent Item Name: Protector - Aft Wall

Start Date: 5/25/2010

Required Date: 5/31/2010

Comments: IPP Rev:A 09-01-14 new issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	1,769.706	2.49	2.621053			



GE PLASTICS LEXAN SHEET

1810-6-7

Location

Loc Qty

Loc Code

MAT

1769.7068

111710

64

112585

173.383

114032

1532.3238

114032

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	59060
<b>Description:</b> Protector – Aft Wall		<b>Part Number:</b>	D3876-7
<b>Inspection Dwg:</b> D3876 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

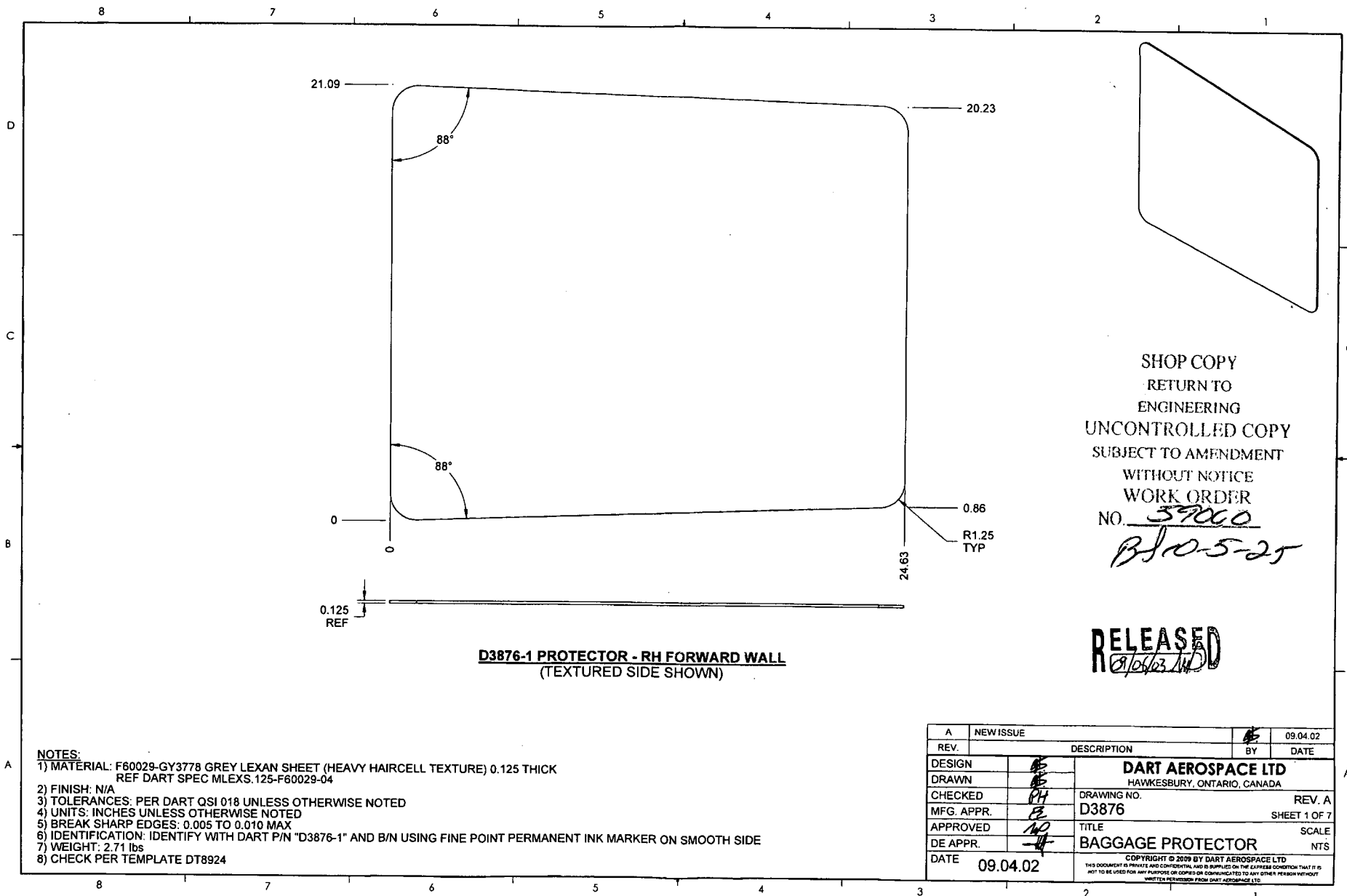
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.63	+/-0.030	1.63	✓			
8.50	+/-0.030	8.50	✓			
15.37	+/-0.030	15.37	✓			
17.00	+/-0.030	17.00	✓			
0.27	+/-0.030	0.27	✓			
1.90	+/-0.030	1.90	✓			
18.24	+/-0.030	18.24	✓			
19.87	+/-0.030	19.87	✓			
20.14	+/-0.030	20.14	✓			
0.125	+/-0.010	0.125	✓			

<b>Measured by:</b>	IB
<b>Date:</b>	10-6-7

<b>Audited by:</b>	S
<b>Date:</b>	10/6/07

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.22	New Issue	KJ	AA



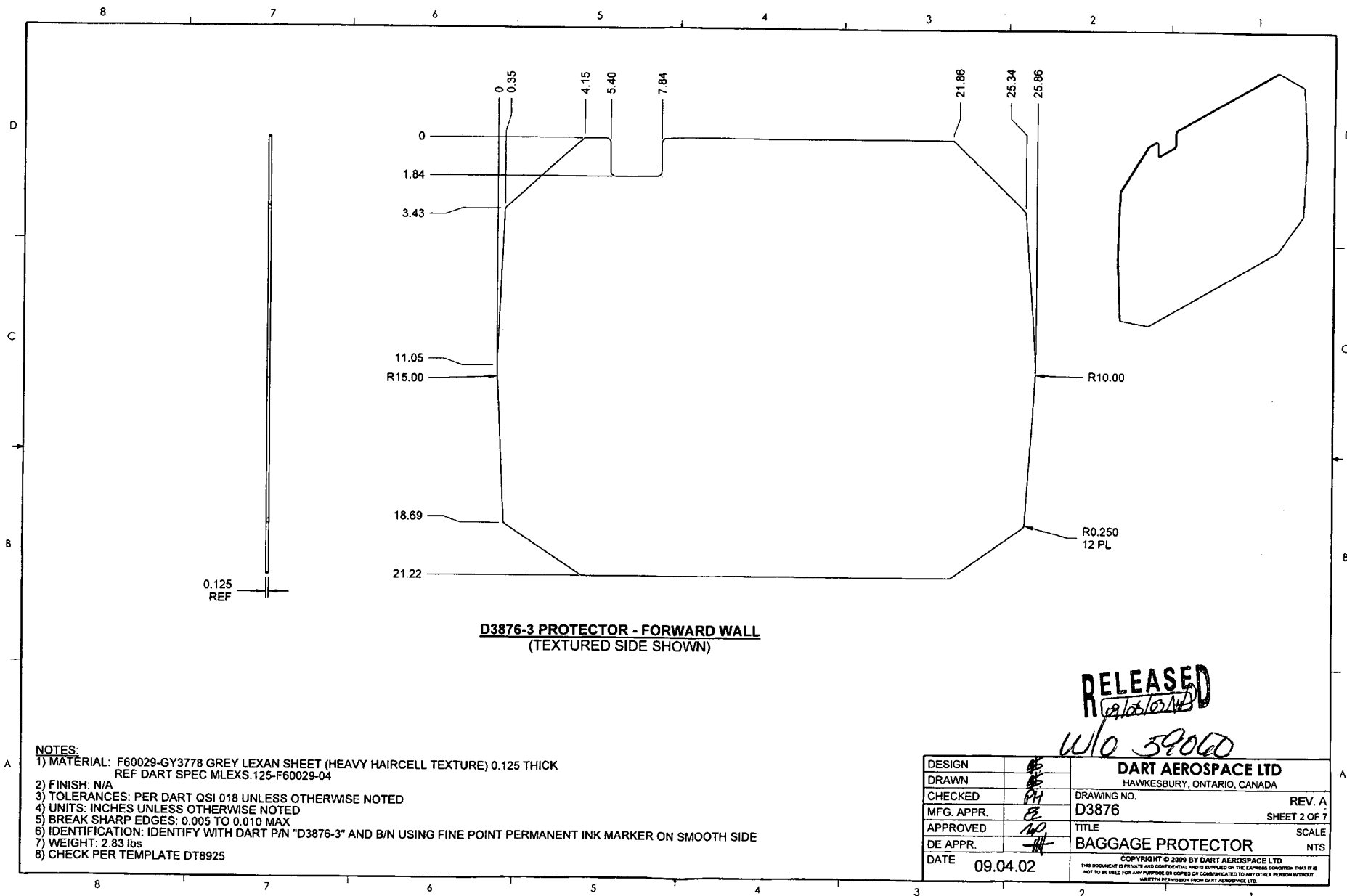
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37000  
B105-25

**RELEASED**  
9/10/03

**NOTES:**

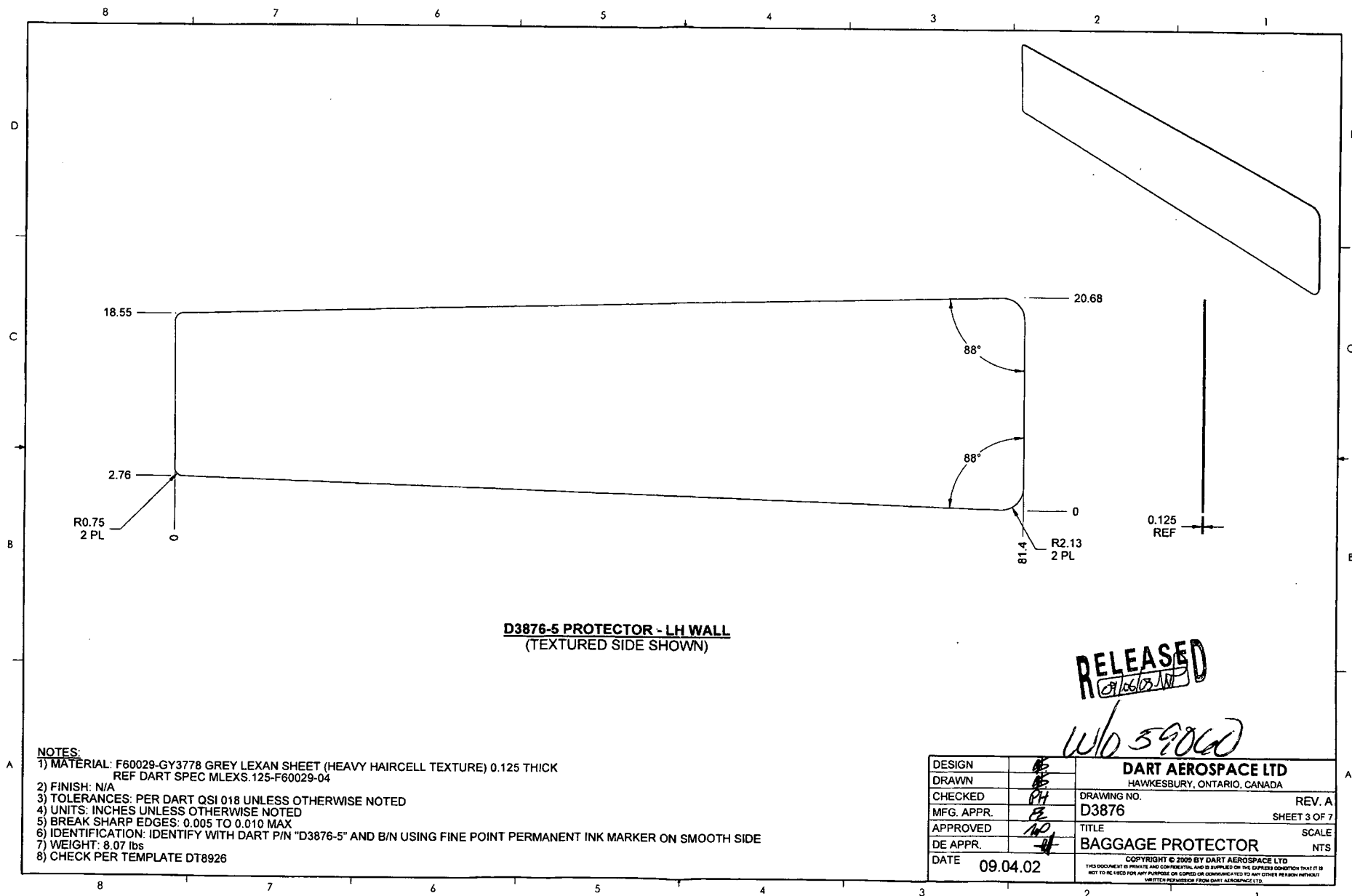
- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK  
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3876-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
- 7) WEIGHT: 2.71 lbs
- 8) CHECK PER TEMPLATE DT8924

A		NEW ISSUE				09.04.02	
REV.		DESCRIPTION			BY	DATE	
DESIGN	<del>1</del>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA					
DRAWN	<del>1</del>						
CHECKED	<del>PH</del>				DRAWING NO.	REV. A	
MFG. APPR.	<del>1</del>				D3876	SHEET 1 OF 7	
APPROVED	<del>1</del>				TITLE	SCALE	
DE APPR.	<del>1</del>	<b>BAGGAGE PROTECTOR</b>				NTS	
DATE	09.04.02			COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

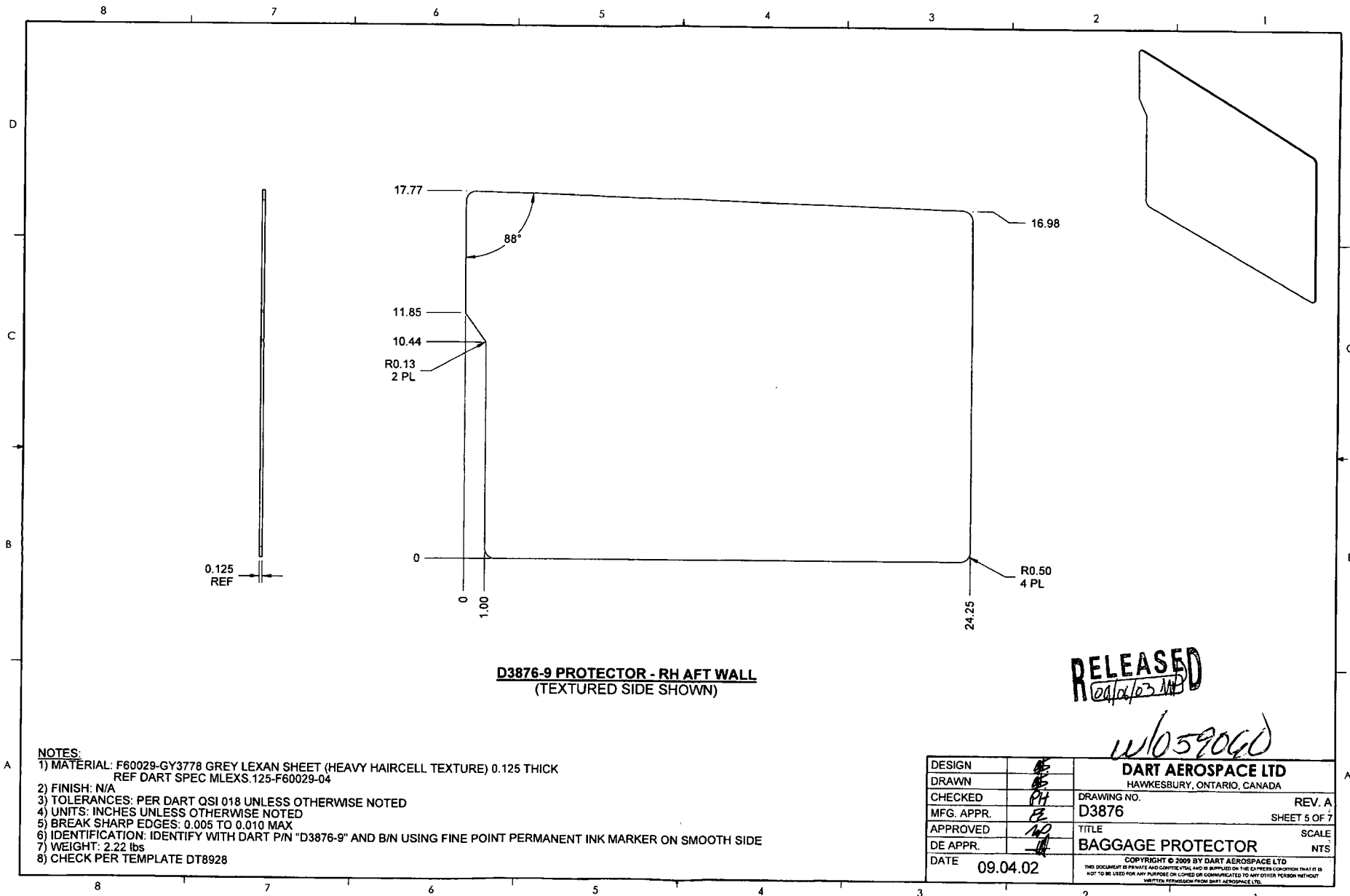


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9/10/04

W10 59060







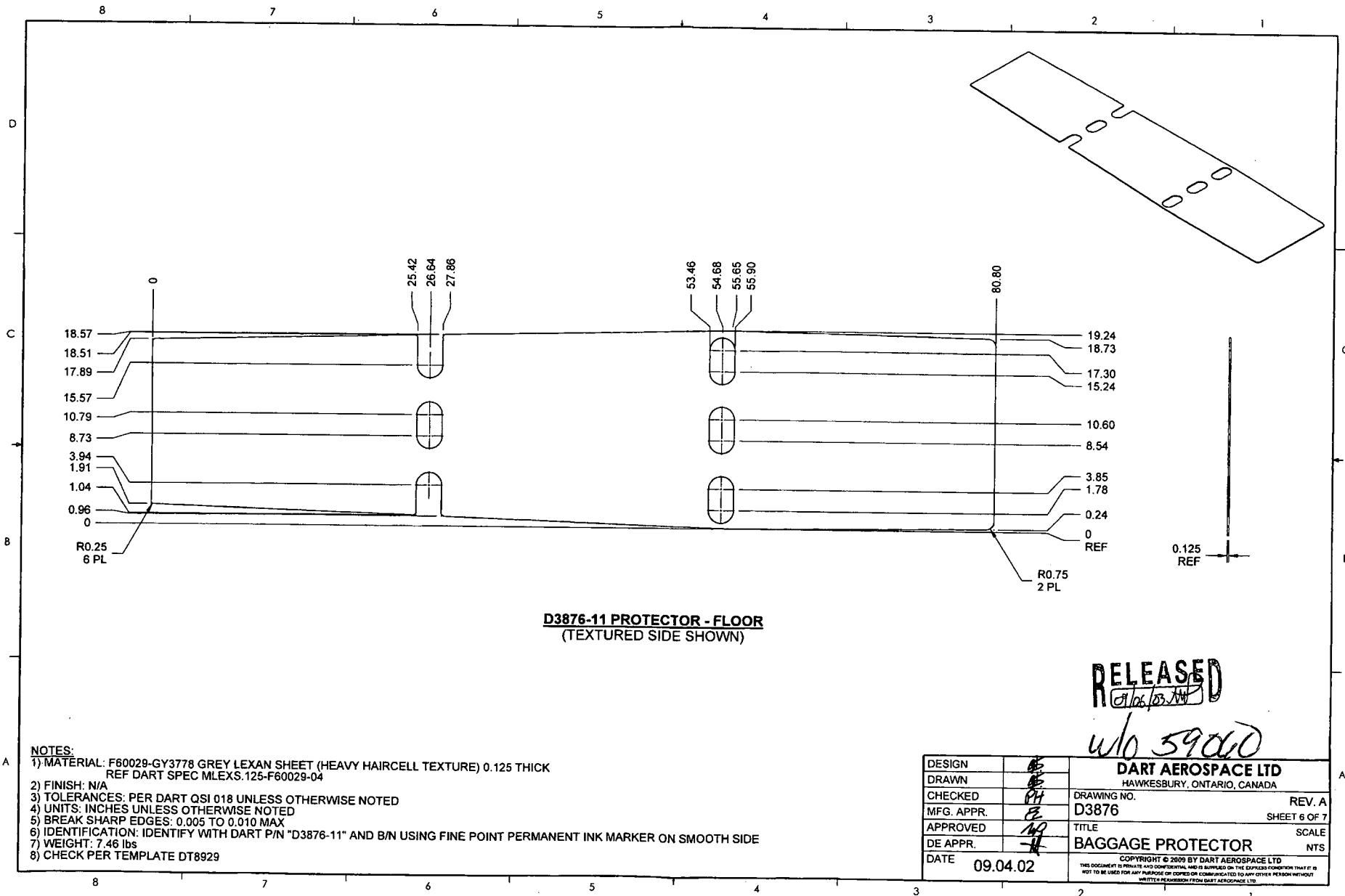
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09/04/02

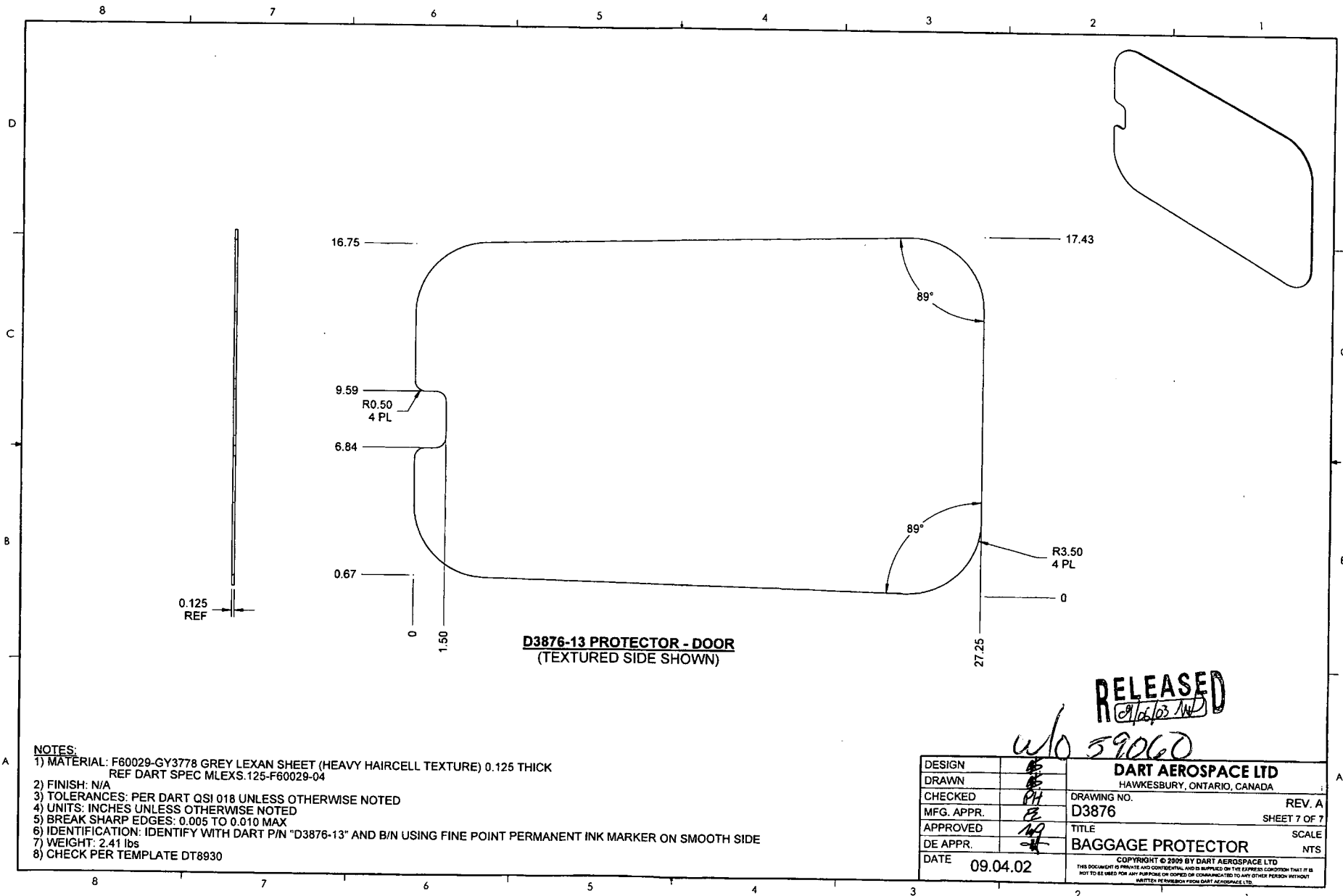
W1059060

**NOTES:**

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK  
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3876-9" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
- 7) WEIGHT: 2.22 lbs
- 8) CHECK PER TEMPLATE DT8928

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3876	SHEET 5 OF 7
APPROVED		TITLE	SCALE
DE APPR.		BAGGAGE PROTECTOR	NTS
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21/06/02

W/0 59060

**NOTES:**

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK  
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3876-13" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
- 7) WEIGHT: 2.41 lbs
- 8) CHECK PER TEMPLATE DT8930

DESIGN	<i>ES</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>ES</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>ES</i>	D3876	SHEET 7 OF 7
APPROVED	<i>149</i>	TITLE	SCALE
DE APPR.	<i>ES</i>	<b>BAGGAGE PROTECTOR</b>	
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